

# Work Order ID 105755

**\*105755\***

Page 1

August-16-13 11:42:11 AM

Item ID: D3188-2M Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: SPACEPOD BODY RH  
 Start Date: 8/16/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 9/13/13 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 13-08-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3188	Rev F

100	PURCHASING	0.00							
-----	------------	------	--	--	--	--	--	--	--

**\*100\***  
 Purchasing  
 Purchasing  
 Memo  
 Issue P/O: 20980  
 Description: D3188-2MBODY  
 SHIP: QTY (8) D2213 Spacers  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 2 Items from Previous steps

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--

**\*110\***  
 Packaging  
 Packaging  
 Memo  
 Ensure a copy of certification of conformity and process sheet from Delastek is attached.

CZ 13/08/19 ①

P93/1425 ①

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

# Work Order ID 105755

\*105755\*

Page 2

August-16-13 11:42:11 AM

Item ID: D3188-2M Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: SPACEPOD BODY RH  
 Start Date: 8/16/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/13/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing  Memo Check for void spot and pins.	0.00  0.00				DAS 27 0.00	14/11/13		
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: CA  Memo	0.00  0.00				DAS 27 0.00	14/11/13		
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00					14/11/13		

14-11-03

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	--	---

# Picklist Print

August-16-13 11:42:14 AM

Page 1

Work Order ID: 105755

**\*105755\***

Parent Item: D3188-2M

**\*D3188-2M\***

Parent Item Name: SPACEPOD BODY RH

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC  
IPP rev B rev D dwg 07.03.07 ec  
IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2213		Manufactured	No			100	Each	106.0000	8	8			
-------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

**\*D2213\***

Insert

\*\*

C213/08/19

Location

Loc Qty

Loc Code

ST006

106

30809

106

D3188-2P		Purchased	No			110	Each	1.0000	1	1			
----------	--	-----------	----	--	--	-----	------	--------	---	---	--	--	--

**\*D3188-2P\***

Spacepod Body

\*\*

105755

14-11-03

Location

Loc Qty

Loc Code

CA

1

95145

1

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

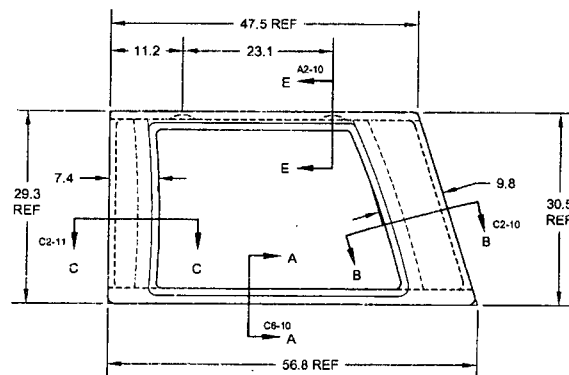
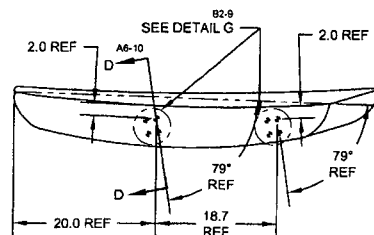
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

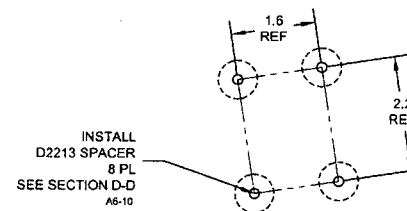
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other _____ _____ _____ _____
---	---	---	--



**D3186-2M SPACEPOD BODY**



**DETAIL G** D6-8

105755 MJS  
13-08-16

**RELEASED**  
2009 -10- 20  
JW

**D3186-2M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	49592
Customer No.	DART US

## Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

## Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200

Contact : Linda Lacelle

Ship Date	Order Date	Our SO #.	Ordered by	Your PO#	Terms
24-10-2013	11-09-2013	23834	Chantal Lavoie	20980	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Mathieu Doucet, ext.690	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0071	Line 1 N° D3188-2M, Spacepod Body RH U of M: Chaque Dwg. D3188 Rév.: F B105755 Serial # Lot # 55561 55561	
1	0	1	DKC134-0060	Line 2 N° D3186-2M Spacepod Door RH U of M: Chaque Dwg. D3186 Rév.: E B105748 Serial # Lot # 55560 55560	

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request*

Accepted by:

*Mathieu Doucet*  
Quality department



AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Date: Lundi, 2013-09-16 13:45:16  
Utilisateur: Mario Chantal

## Feuille de Procédé

4 / ASAP

<b>Client</b> :	DART US DART AEROSPACE	<b>Nom Dessin</b> :	SPACEPOD BODY RH
<b>Numéro Job</b> :	55561	<b>Numéro Article</b> :	DKC134-0071
<b>Numéro</b> :	3763	<b>Numéro Dessin</b> :	—
<b>Numéro B.A.</b> :		<b>Projet Numéro</b> :	DK-362
<b>Cette fois</b> :	2013-09-16 No. :	<b>Révision dessin</b> :	
<b>Prsht Rev.</b> :	NC	<b>Matériel</b> :	Fibre 7781 et résine 411-350
<b>Prem. fois</b> :	—	<b>Date Dûe</b> :	2013-09-16
<b>Job précédente</b> :	45779	<b>Qté:</b>	1 Ud UNITE
<b>Écrit par</b> :			
<b>Vérifié &amp; Approuvé par</b> :			
<b>Commentaires</b> :	N° de dessin: D3188-2M rev. F		

E.O.: N/A



Feuille de Procédé Rév.: 06 AMB0349 remplacé par  
AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

## Produit additionnel

Numéro Job:










# Séq.:	Machine ou	Description :
1.0	AAC1616	N° 83634, Frekote Loctite Wolo
<b>Comment</b>	Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s) N° 83634, Frekote Loctite Wolo	N° de Lot: <u>N/A</u>
2.0	PRÉPARATION	Préparation du moule
<b>Comment</b>	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs  Faire la préparation du moule selon IF134-0020. Date: <u>17/09/13</u> Sceau:  <u>4460 R.L</u>	
3.0	AAC1885	Tissu à délaminer Release ply B
<b>Comment</b>	Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s) Tissu à délaminer Release ply B	# de Lot: <u>N/A</u>
4.0	AAC1887	Wrightlon 5200 Bleu P3
<b>Comment</b>	Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s) Wrightlon 5200 Bleu P3	# de Lot: <u>N/A</u>
5.0	AC0885	Feutre de drainage N° Airweave N 10
<b>Comment</b>	Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)	

Date: Lundi, 2013-09-16 13:45:16

Utilisateur: Mario Chantal










## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD BODY RH
Numéro Job:	55561	Numéro	DKC134-0071
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
6.0	AC0943	Stretchlon 200 poche à vide Vert	
Comment	Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)		
7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	
Comment	Qty.: 11.40 VERGE(s)/Unit Total : 11.40 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish	N° de Lot: 1-41291-1	
8.0	AMB0511	N° TG-13-U, Fiberglass 13 oz	
Comment	Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s) N° TG-13-U, Fiberglass 13 oz	N° de Lot: 1-36302-1	
9.0	AMB0213	WR1850 Roving 18oz x 50"	
Comment	Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s) WR1850 Roving 18oz. x 50"	N° de Lot: 1-35539-1	
10.0	AC0886	Ruban à gommer jaune #: T/AT-200Y	
Comment	Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)		
11.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs		
Tailler les tissus selon IF134-0020.			
Date:	17/09/13	Sceau:	
12.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s) Catalyst N° DDM-9	N° de Lot: 1-27929-1	
13.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s) Résine (411B7530) 411-350 promo. 75min.	N° de Lot: 1-42176-1	
14.0	AAC1540	Fibre de verre Miapoxy 66	
Comment	Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s) Fibre de verre Miapoxy 66	N° de Lot: 1-40092-2	
15.0	PREP-GENERAL	Préparation du matériel	
			
Comment	Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs		
Laminer la 1ère coquille selon IF134-0020.			
Date:	17/09/13	Sceau:	 4460 R.L.

Date: Lundi, 2013-09-16 13:45:16

Utilisateur: Mario Chantal











## Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: SPACEPOD BODY RH	
Numéro Job: 55561		Numéro DKC134-0071	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
16.0	AMB0355	ATC core-cell A500 plain 4'x8' 1" thick	
Comment Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s)		N° de Lot: 1-38256-1	
ATC core-cell A500 plain 4'x8' 1" thick			
17.0	TAILLAGE	Faire le taillage du matériel	
			
Comment Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs			
Tailler et ajuster les Foam Core selon IF134-0020.			
Date: 12-09-13 Sceau: 4460RL			
18.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment Qty.: 0.136 KILOGRAMME(s)/Unit Total : 0.136 KILOGRAMME(s)		N° de Lot: 1-42176-1	
Résine (411B7530) 411-350 promo. 75min.			
19.0	AMB0286	Catalyst N° DDM-9	
Comment Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s)		N° de Lot: 1-27829-1	
Catalyst N° DDM-9			
20.0	FINITION	Finition Générale	
			
Comment Setup: 0.00Hrs/-Run: 20.0000Min Total Run : 0.3333Hrs			
Sceller les foam core selon IF134-0020.			
Date: 19-09-13 Sceau: 4460RL			
21.0	PERCAGE	Perçage de trous	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Perçer les foam core selon IF134-0020.			
Date: 19-09-13 Sceau: 4460RL			
22.0	AAC1611	Polybond B46F	
Comment Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)		N° de Lot: 1-38189-1	
Polybond B46F			
23.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs			
Installer les foam core selon IF134-0020.			

Date: Lundi, 2013-09-16 13:45:16

Utilisateur: Mario Chantal

## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD BODY RH
Numéro Job:	55561	Numéro	DKC134-0071
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
	Date: <u>23/09/13</u> Sceau: <u>4460 RL</u> 		
24.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-41428-1</u>		
25.0	FINITION	Finition Générale	
			
Comment	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  Usiner les foam core selon IF134-0020.  Date: <u>26-09-13</u> Sceau: <u>4460 RL</u> 		
26.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment	Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-42176-1</u>		
27.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
28.0	LAMINAGE	Faire le laminage	
			
Comment	Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  Laminer les plis de 9oz selon IF134-0020.  Date: <u>27-09-13</u> Sceau: <u>4460 RL</u> 		
29.0	TRIMAGE	Trimage	
			
Comment	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  Faire le taillage selon IF134-0022.  Date: <u>30-09-13</u> Sceau: <u>4460 RL</u>		
30.0	AMB0286	Catalyst N° DDM-9	
Comment	Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>		
31.0	AAC1540	Fibre de verre Miapoxy 66	
Comment	Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: _____		

Date: Lundi, 2013-09-16 13:45:16

Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: SPACEPOD BODY RH

Numéro Job: 55561

Numéro DKC134-0071

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
32.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-42176-1

33.0	LAMINAGE	Faire le laminage
------	----------	-------------------



Comment Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

Date: 3/10/13 Sceau: 4460 R.L.



34.0	AAC1610	Spacer N° D2213
------	---------	-----------------

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Spacer N° D2213 N° de Lot: 1-42317-1

35.0	ASSEMBLAGE	Assemblage mécanique
------	------------	----------------------



Comment Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG 0097.

Date: 4/10/13 Sceau: 4460 R.L.



36.0	AAC1021	Dupont Primer N° 7704S
------	---------	------------------------

Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-37302-1

37.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase
------	---------	---

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40542-1

38.0	FINITION	Finition Générale
------	----------	-------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Date: 7/10/13 Sceau: 4460 R.L.



39.0	PRIMER	Application primer
------	--------	--------------------



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 8-10-13 Sceau: 20



# de fiche de mélange: 6478

Date: Lundi, 2013-09-16 13:45:16

Utilisateur: Mario Chantal

## Feuille de Procédé

Cient: DART US DART AEROSPACE Nom Dessin: SPACEPOD BODY RH  
Numéro Job: 55561 Numéro DKC134-0071

Numéro Job:



# Séq.: Machine ou Opération: Description :

40.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-411928-1

41.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

Faire les réparations de finition s'il y a lieu selon IG 0008.

Date: 10-10-13 Sceau: 4460AL



42.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-42451-1

43.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40542-1

44.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon IG 0008.

Date: 11-10-13 Sceau: 20 # de fiche de mélange: 6482



45.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.

Date: 23 oct 13 Sceau: IV Initiales: IV



46.0 EMBAL / ENTREPO Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage selon IG 0057

Date: 23 oct 2013 Sceau: 14



Tape de masquage resté collé sur la pièce à l'intérieur  
Manque de primer  
Coulisse primer

